

Work Order ID 58896

May 20, 2010 10:48:32 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Item Name: Armrest Assembly

Stop



Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *V*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3780	Rev D

100



Small Fab

0.00

(6)

Small Fab

Memo

DISASSEMBLE 6 X D3780-041 B56891
KEEP PARTS TO REASSEMBLE
SB 10/06/15

BRING D3696-041 TO MANUAL MILL

101



Mill Conv

Conventional Milling Machine

0.00

0.00

B.A 10/06/15
6

102



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

B.A 10/06/15
6

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Item ID: D3780-041

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Stop



Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

103

QC8- Inspect parts - second check

0.00

0.00

5/10/06/15

6 15



QC

Quality Control

104

0.00



Small Fab

Memo

0.00

Small Fab

REASSEMBLE, USING ORIGINAL PARTS PER DRWG D3780

5/10/06/16 ⑥

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

0.00

5/10/06/16

⑦

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Item ID: D3780-041

Accept



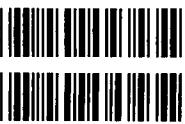
Setup Start



Revision ID:

Item Name: Armrest Assembly

Stop



Start Date: 5/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120

Operation
DescriptionIdentify as per dwg & Stock Location: 185Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-6-18 SFCX

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

130



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/21 SFMF 10-6-21

Picklist Print

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Page 1

Work Order ID: 58896



Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 5/19/10

Required Date: 5/28/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ D3780-041	Replacement	Mfg/ Manufactured	Bin	Primary No	Last	Route	Unit of Each	Qty on 6.0000	Qty per Kit	Qty	Date	Status
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Armrest Assembly

Location	Loc Qty	Loc Code
ST261	6	
56891	6	

EJ 10/06/16
6

MS24665-302 QTY=6 1113644
cotter Pin

EJ 10/06/16

DART AEROSPACE LTD	Work Order:	58896
Description: ARM ASSEMBLY	Part Number:	D3696 D3696-1
Inspection Dwg: D3696 Rev: D		Page 1 of 1

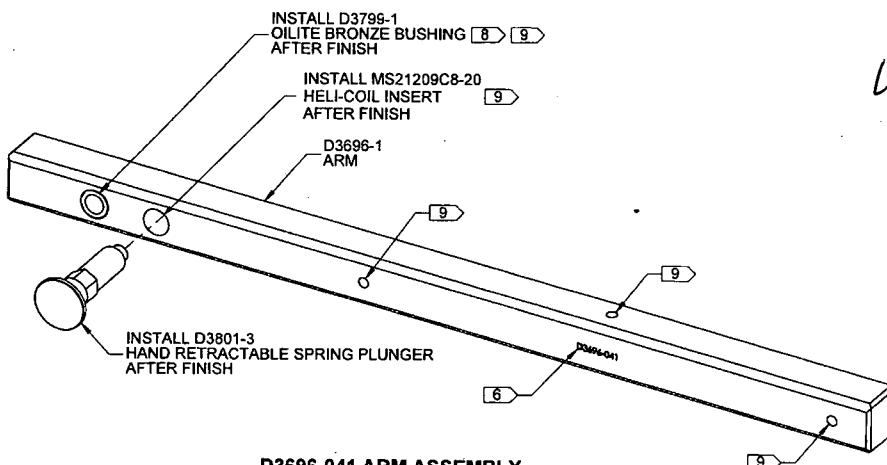
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	J.A	Audited by:	Any	Prototype Approval:	N/A
Date:	10/06/15	Date:	10/06/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



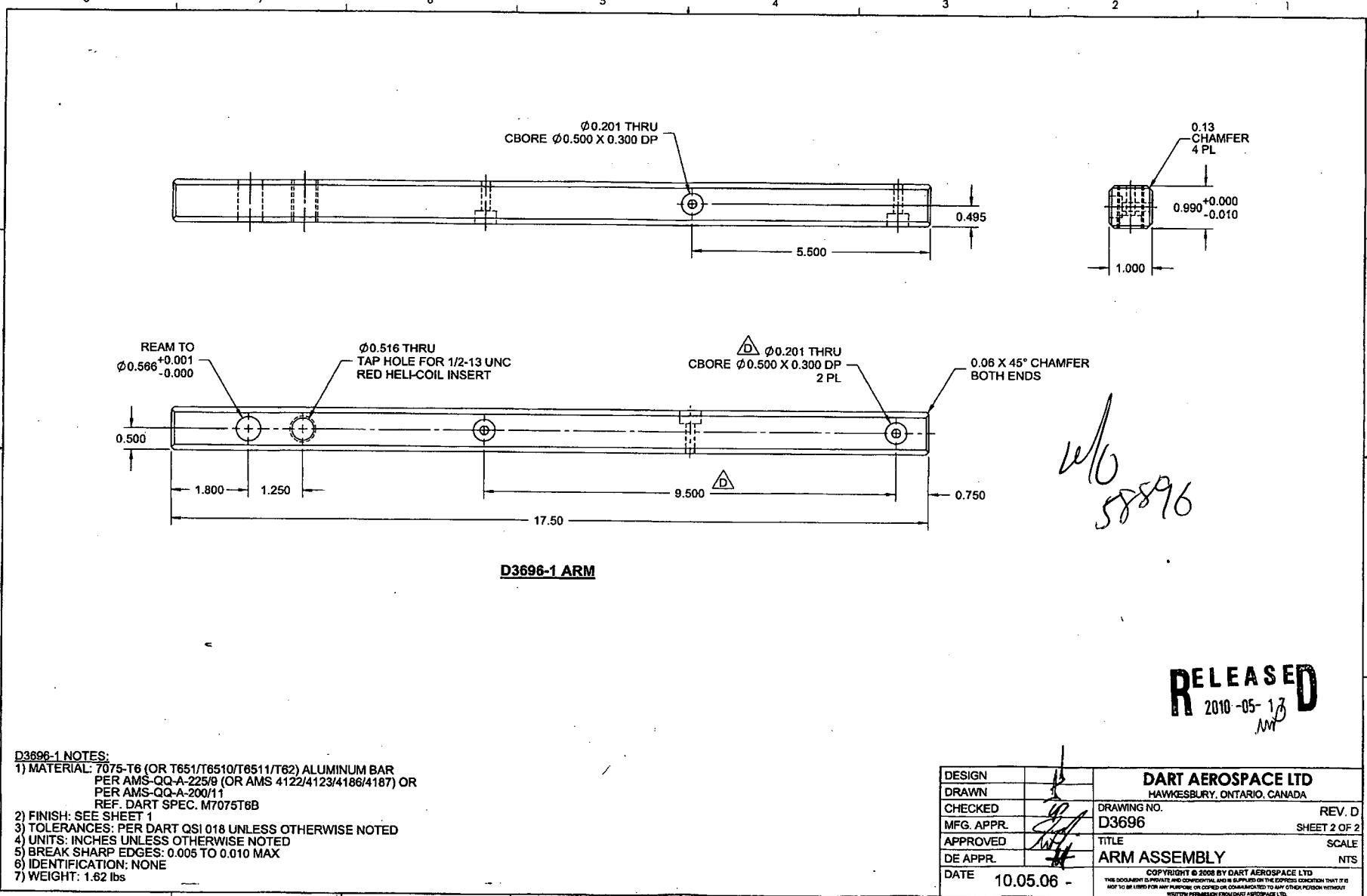
D3696-041 ARM ASSEMBLY

RELEASED
2010-05-17
JMP

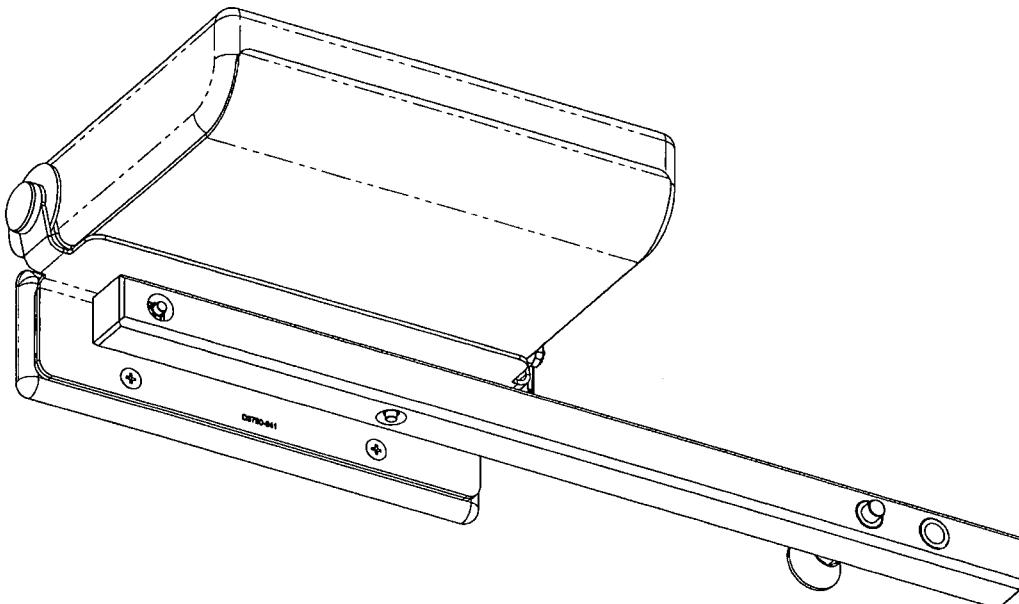
D3696-041 NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES:N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
 - 7) WEIGHT: 1.68 lbs
 - 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
 - 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

D	REVISED ITEM 5 AS FOLLOWS: '0.201 THRU CBORE Ø0.050 X 0.300 DP' WAS 2 PL (ZN CA-2). REASON: ADDITION OF ALTERNATE ARMREST CUSHION. INSTALLATION D412-76-105 BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	10.05.06
C	REVISED ITEM 5 AS FOLLOWS: '0.201 THRU CBORE Ø0.050 X 0.300 DP' WAS 2 PL (ZN CA-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1). P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL. DESIGN ASSISTANT: '0.201 THRU CBORE Ø0.050 X 0.300 DP' WAS 2 PL (ZN BB-2). 1,000 WAS 0.990 +0.000,-0.010 (ZN CA-2). POCKETS REMOVED. REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>b</i>	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>b</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>b</i>	D3696	SHEET 1 OF 2
APPROVED	<i>b</i>	TITLE	SCALE
DE APPR.	<i>b</i>	ARM ASSEMBLY	NTS
DATE	10.05.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE, OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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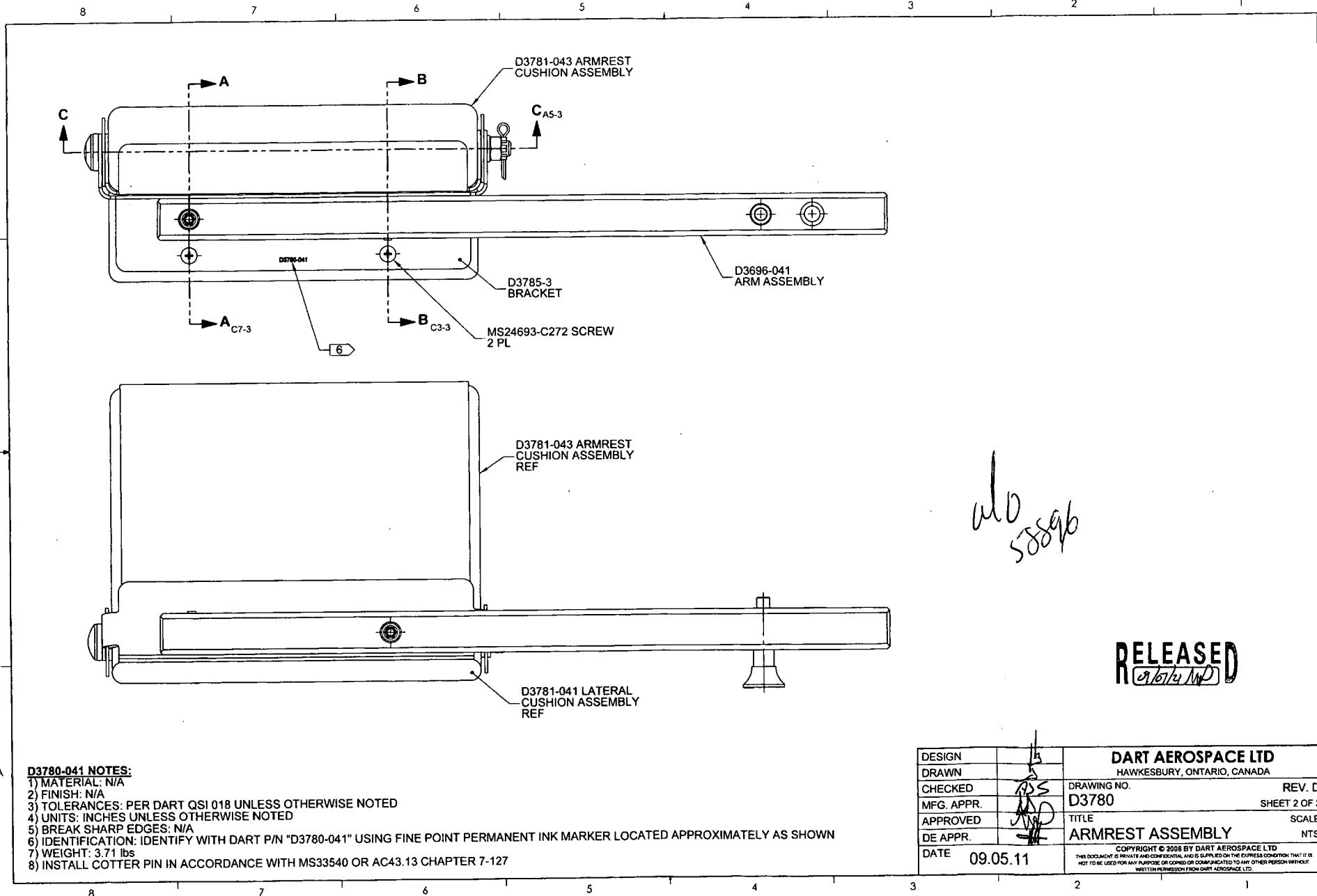
D3780-041 ARMREST ASSEMBLY

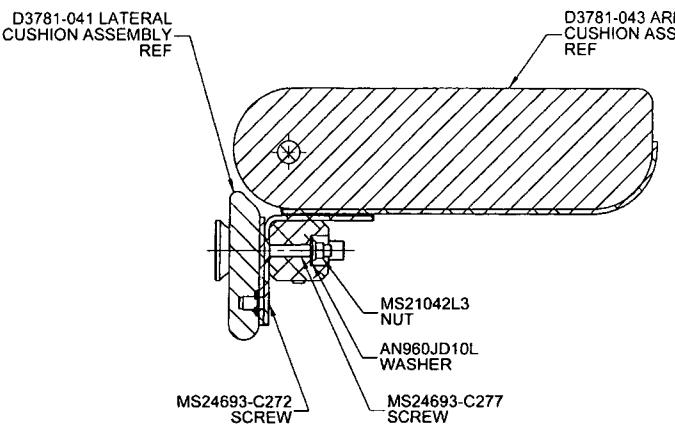
ITEM	QTY	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

RELEASED
09/07/21 MWD

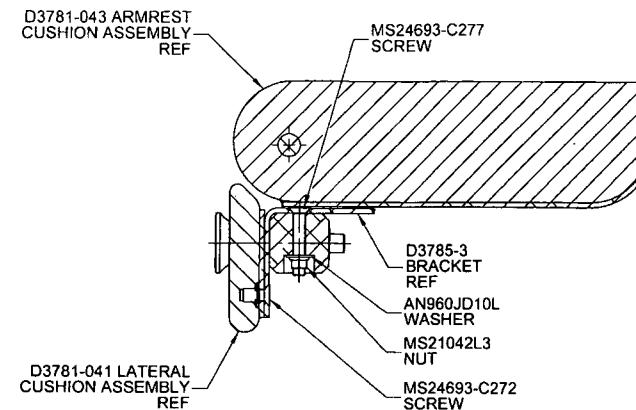
D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>13</i>		
CHECKED	<i>13</i>	REV. D	
MFG. APPR.	<i>13</i>	DRAWING NO. D3780 SHEET 1 OF 3	
APPROVED	<i>13</i>	TITLE	SCALE
DE APPR.	<i>13</i>	ARMREST ASSEMBLY NTS	
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS NOT CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED OR FOR OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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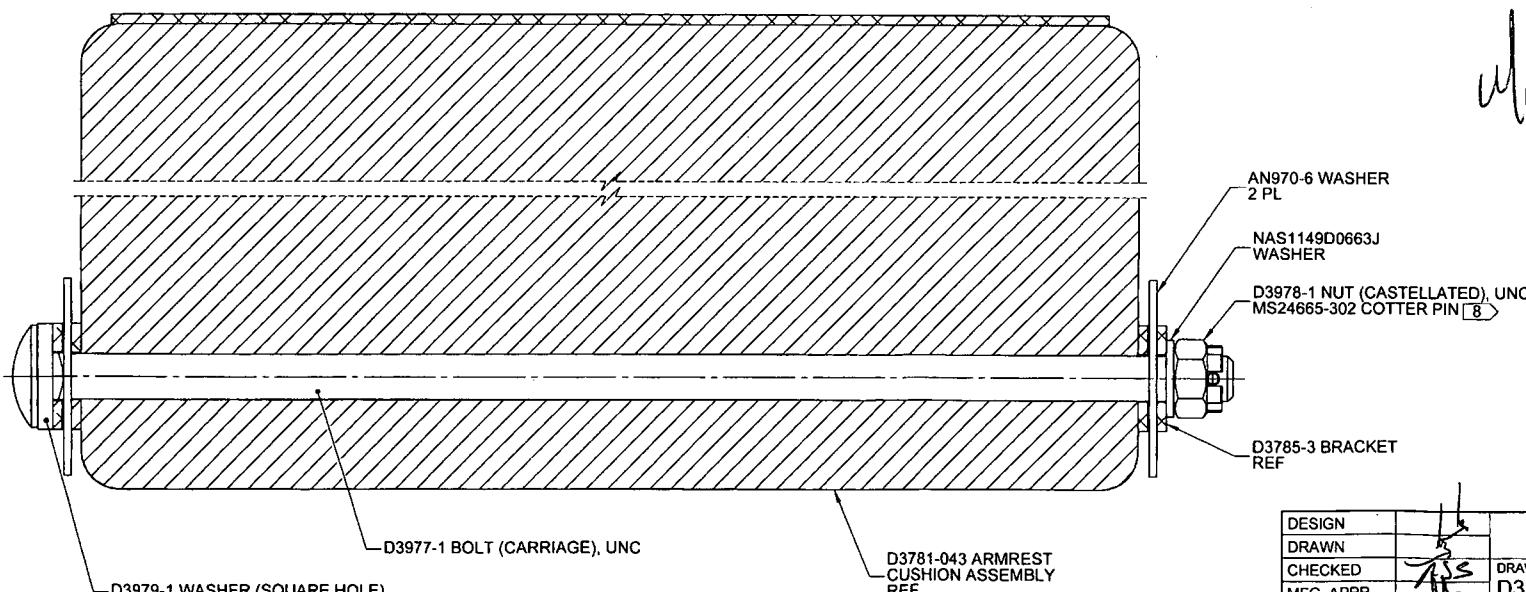




SECTION A-A C7-2



SECTION B-B C6-2



SECTION C-C DS-2
SCALE: 2X

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. D
APPROVED		D3780
DE APPR.		SHEET 3 OF 3
DATE	09.05.11	TITLE
		ARMREST ASSEMBLY
		SCALE
		NTS

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RELEASED
01/07/14 MHD